

ment, a two V-clamping jig is obtained having a three-point support. This drill jig was accurate, rapid and easily operated. Drill Jig for Machining Half Holes. — A rather unusual form of jig for drilling a half hole in the work to match a similar half hole in another piece is shown in Fig. 9. Holes are often drilled in such locations when it is desired to assemble two pieces and drive a pin into the hole to act as a driver. To drill such a half hole, it is usually necessary to plug up the hole in the work in some way which will back up the side of the drill that is not cutting. This is accomplished in the present instance

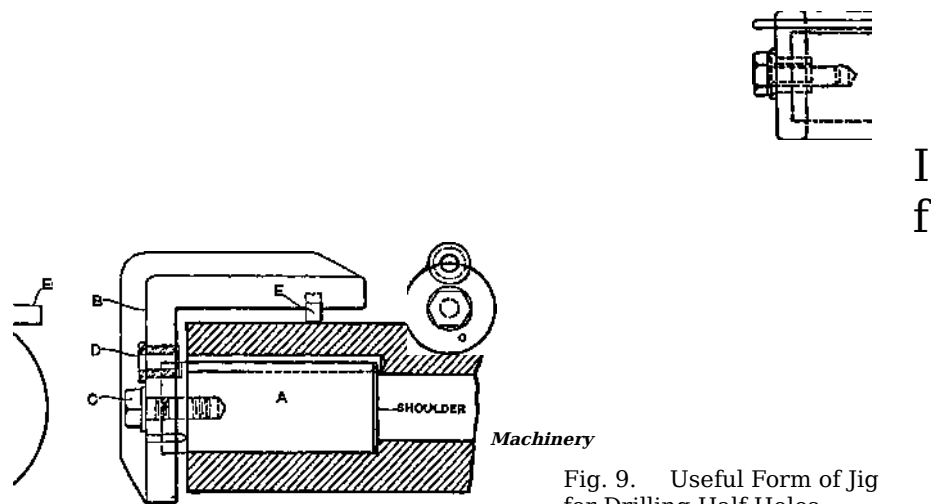


Fig. 9. Useful Form of Jig for Drilling Half Holes

by having a stud *A*, which is a push fit in the work, back up the drill. An angle-iron or plate *B* is attached to the stud *A* and held in position by a bolt *C*, the plate *B* being also doweled in place. A hole is drilled in this angle-iron to receive the bushing *D* which guides the drill in the

usual manner. The remainder of the jig consists of the key *E* which locks the jig in place on the work.

In using this tool, the key *E* is pulled back clear of the work and the stud *A* which carries the angle-iron is pushed into the hole until the stud brings up against the shoulder of the work. By pushing the tapered key *E* up until it binds on the